

Order to ship Sept 14.

Work Order ID 136307

136307

Page 1

Item ID: D3049-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 9/1/2015

Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/8/2015

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: SH Date: 20150906

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3049	Rev A1

110 0.00

110

Waterjet

Memo

0.03

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3049-1_BLANK

(4)

02/15/09/03

120 0.00

120

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.05

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
3-Deburr

4

0

15/09/15

130 0.00

130

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

4

0

15/09/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
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OTHER : ☐																					

Work Order ID 136307

September 01, 2015 2:10:37 PM

136307

Page 2

Item ID: D3049-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 9/1/2015

Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/8/2015

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

DAS
14
9-89

15/09/15

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Packaging

Memo

0.00

Packaging

DAS
27
9-89

SEP 16 2015

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.01

Quality Control

MC5

SEP 16 2015

MC5

SEP 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

September 01, 2015 2:11:14 PM

Page 1

Work Order ID: 136307

136307

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	235.8810	3.4	13.6			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

09/15/09/03

Location

Loc Qty

Loc Code

MAT

189.514

m131661

43.514

m132063

146

MAT018

46.367

m131335

46.367

15

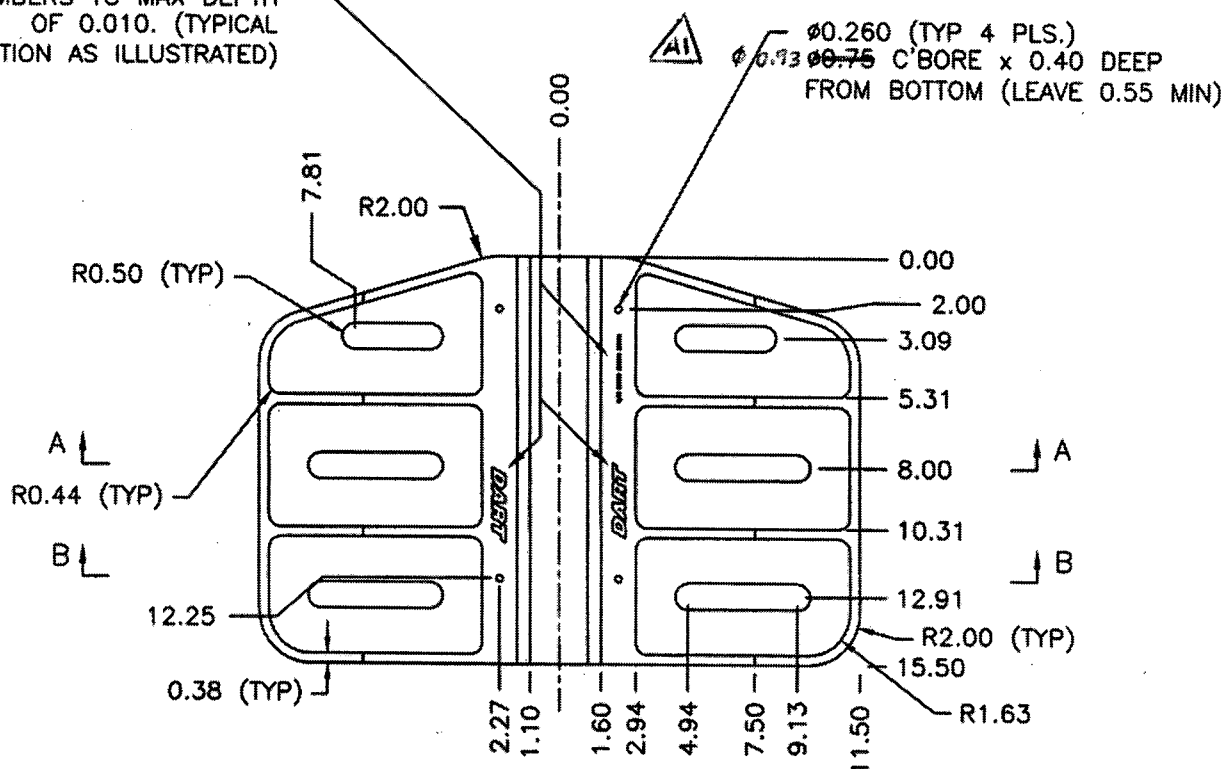


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	# 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED
01.10.24

20150901
136307
SH

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

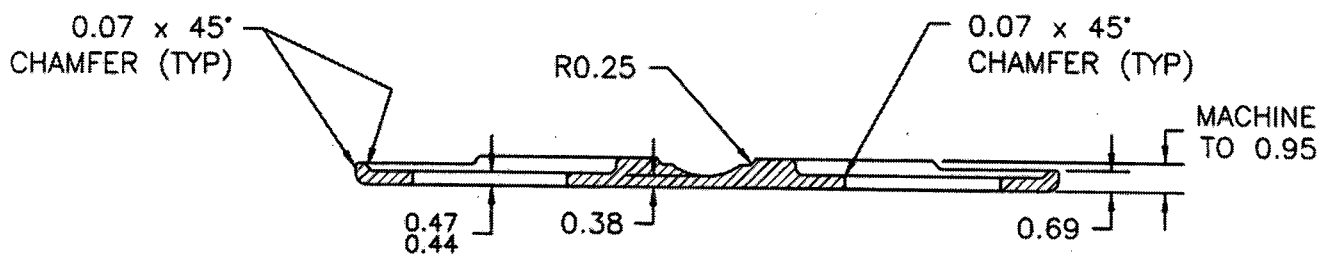
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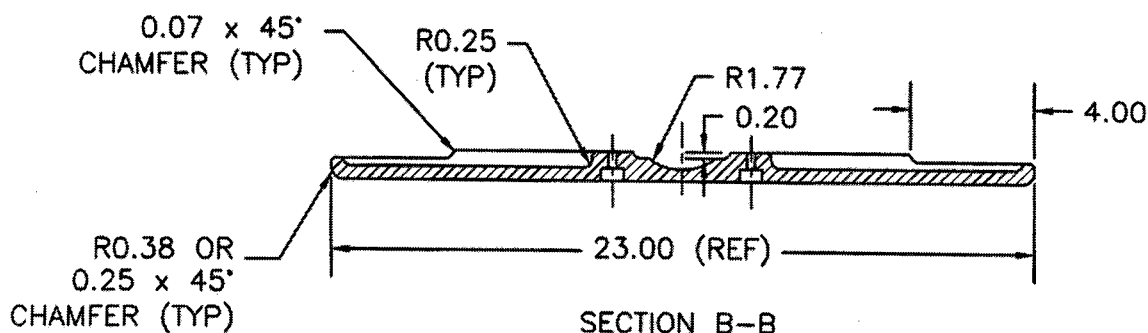


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 #



SECTION A-A



SECTION B-B

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DART AEROSPACE LTD		Work Order:	136307
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	0,260	✓		MJP-04	vern
B	0.93	+/-0.030	0,930	✓		...	...
C	0.40	+0.030/-0.000	0,420	✓			
D	2.00	+/-0.030	1,996	✓			
E	10.250	+/-0.010	10,250	✓			
F	4.540	+/-0.030	4,540	✓			
G	5.88	+/-0.030	5,880	✓			
H	0.38	+/-0.030	0,380	✓			
I	11.50	+/-0.030	11,500	✓		MJP-07	Tape
J	0.07 x 45°	+0.030/-0.010	0,050 x 45°	✓		MJP-04	vern
K	0.44 - 0.47	+/-0.000	0,447	✓		...	...
L	R0.25	+/-0.030	0,250	✓		—	Radius gauge
M	0.38	+/-0.010	0,380	✓		MJP-04	vern
N	0.95	+0.030/-0.010	0,965	✓		...	...
O	0.69	+/-0.030	0,700	✓		...	
P	0.20	+/-0.030	0,208	✓		MJP-08	Dial depth Mic
Q	23.00	+/-0.030	23,000	✓		MJP-07	Tape
R	0.25 x 45°	+/-0.030	0,260 x 45°	✓		MJP-04	vern

Measured by:	<i>[Signature]</i>	Audited by:	DAS 14	Prototype Approval:	N/A
Date:	15/09/15	Date:	15/09/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	